

Date: Friday, 9/21/2007 12:59:43 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 34782		Part Number	: D2885		
Estimate Number	: 10376		Drawing Number	: D2885 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/21/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/3/2007 Qty: 40 Um: Each		
Previous Run	: 32627					
Written By						
Checked & Approved By						
Comment	: Est A 99.10.12 New Issue EC Est Rev.B Now 6060-T6 06-06-23 JLM Est Rev.C waterjet 06-07-23 ec					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.0270 sf(s)/Unit Total: 1.0794 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.080" Thick Batch <u>M104421</u> HB07-09-28		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2885 Dwg Rev: <u>B</u> HB 07-09-28 <span style="margin-left: 100px;">(48)</span> Prog Rev: <u>B</u>		
2-Deburr if necessary <span style="margin-left: 100px;">B 07/10/03</span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>HB 07-09-28</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>Sc 07/10/03</u> <span style="margin-left: 100px;">(48) counts</span>		
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<u>M-f</u> 07/10/09		
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

Job Number: 34782

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



coac 10

Comment: INSPECT WORK TO CURRENT STEP

08/10/09 448

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/10/09 (48)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10 48

Job Completion



08/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34782
Description: Saddle Spacer	Part Number:	D2885
Inspection Dwg: D2885      Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

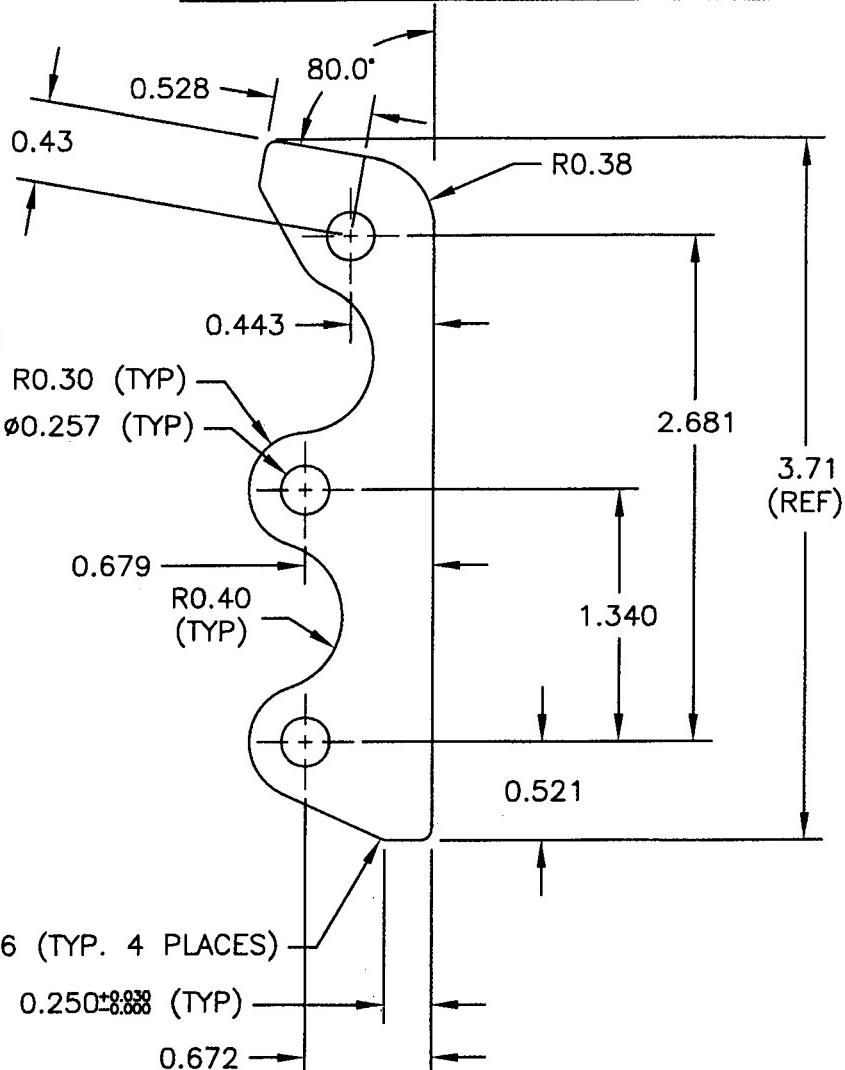
## X First Article      Prototype

Measured by:	HS	Audited by:	CS	Prototype Approval:	N/A
Date:	07-09-29	Date:	07/09/23	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B	SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1	
A	99.04.01	NEW ISSUE		
B	06.05.29	ADD 6061-T6 MATERIAL		

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) SHOP COPY  
0.080" THICK (REF DART SPEC M5052H32S.080) RETURN TO  
ENGINEERING
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 UNCONTROLLED COPY
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES WORK ORDER  
NO. *34782*

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